

Page 1

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 86947

86947

Page 2

July-09-12 2:57:26 PM

Item ID: D2665-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle, LH Fwd Aft Out 206
 Start Date: 7/09/12 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 8/17/12 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|-------------------|----------|--------------|---------------|---------------|------------------|----------------|
| 130 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | DAS 14 8-89 | 12/09/26 | | 4 | 0 | | |
| Quality Control | | | | | | | | | |
| 140 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | 4 | 76 | 12-9-26 | |
| Hand Finishing | | | | | | | | | |
| 150 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| Powdercoat | Memo | 0.00 | | | | | | | |
| Powder Coating | START TIME: 1:20 | | | | | | | | |
| | FINISH TIME: 32001- | | | | | | | | |
| | OVEN TEMPERATURE: 1750 | | | | | | | | |

m122878

MT
12/09/26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Work Order ID 86947

July-09-12 2:57:26 PM

86947

Page 3

Item ID: D2665-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, LH Fwd Aft Out 206
Start Date: 7/09/12 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/17/12 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | 4 | 0 | 12-9-26 | 34 |
| Quality Control | | | | | | | | | |
| 170 | Identify as per dwg & Stock Location: 434 | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | 4 | 8 | 12/9/27 | |
| Packaging | | | | | | | | | |
| 180 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | 12/9/28 | |
| Quality Control | | | | | | | | | |

MLC 12-09-27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

July-09-12 2:57:25 PM

Page 1

Work Order ID: 86947

Parent Item: D2665-1

Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 7/09/12

Required Date: 8/17/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house processEC
IPP Rev:D As per Rev D 07-03-19 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|----------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6101-003 Saddle Billet, 7075 | | Manufactured | No | | | 100 | Each | 55.0000 | 1 | 129-24 | | | |

Location

Loc Qty

Loc Code

MAT040

26

73775

2

73780

7

78599

10

80765

0

MAT042

28

81924

35

MAT044

1

73769

1

87498

4

| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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|--|--|---------------------|----------------|
| DART AEROSPACE LTD | | Work Order: | 86997 |
| Description: 206 Saddle, Outboard, Left side | | Part Number: | D2665-1 |
| Inspection Dwg: D2665 Rev: D DSK: Rev: | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION DIMENSION SHEET

| Dim | Min | Max | Go/No Go Gauge | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|---|
| | | | | 1 | 2 | 3 | 4 | 5 |
| A | 0.100 | 0.140 | | .117 | .119 | .120 | .118 | |
| B | 0.100 | 0.140 | | .109 | .110 | .113 | .115 | |
| C | 1.125 | 1.145 | | 1.135 | 1.134 | 1.130 | 1.130 | |
| D | 0.615 | 0.685 | | .650 | .650 | .650 | .650 | |
| E | 0.240 | 0.260 | | .254 | .253 | .257 | .258 | |
| F | 1.313 | 1.343 | | 1.327 | 1.328 | 1.328 | 1.328 | |
| G | 0.210 | 0.230 | | .219 | .220 | .220 | .220 | |
| H | 0.100 | 0.180 | | .130 | .130 | .130 | .130 | |
| I | 2.470 | 2.510 | | 2.490 | 2.490 | 2.490 | 2.490 | |
| J | 1.565 | 1.585 | | 1.575 | 1.572 | 1.569 | 1.569 | |
| K | 0.235 | 0.240 | | .236 | .237 | .237 | .237 | |
| L | 0.100 | 0.120 | | .116 | .112 | .112 | .112 | |
| M | 0.990 | 1.010 | | 1.003 | .999 | .999 | .999 | |
| N | 0.510 | 0.515 | | .512 | .512 | .512 | .512 | |
| O | 5.990 | 6.010 | | 6.002 | 6.002 | 6.002 | 6.002 | |
| P | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | |
| Q | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | |
| R | 0.312 | 0.318 | | .314 | .314 | .314 | .314 | |
| S | 0.315 | 0.322 | | .316 | .316 | .316 | .316 | |
| T | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | |
| U | 1.357 | 1.367 | | 1.362 | 1.362 | 1.362 | 1.362 | |
| V | 0.787 | 0.807 | | .795 | .795 | .794 | .796 | |
| W | 0.540 | 0.560 | | .550 | .551 | .551 | .551 | |
| X | 1.674 | 1.684 | | 1.679 | 1.679 | 1.679 | 1.679 | |
| Y | 0.256 | 0.262 | | .258 | .258 | .258 | .258 | |
| Z | 0.912 | 0.932 | | .924 | .922 | .924 | .925 | |
| AA | 0.490 | 0.510 | | .500 | .503 | .501 | .505 | |
| AB | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | |
| AC | | | | | | | | |
| AD | | | | | | | | |
| AE | | | | | | | | |
| Accept/Reject | | | | | | | | |

| | | | |
|----------------------------|-------------|--------------|-----------------|
| Measured by: | <i>SDAS</i> | Date: | <i>12-9-24</i> |
| Audited by: | <i>14</i> | Date: | <i>12/09/25</i> |
| Prototype Approval: | | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 99.04.19 | Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A | RF | |
| C | 99.11.10 | Added Dim. R-T | RF | |
| D | 02.12.12 | Reformat; Added Dim. U-W & DT8683, DT8686 | KJ/RF | |
| E | 06.07.05 | Revised per drawing revision C | KJ/JLM | |
| F | 07.03.21 | Revised per drawing revision D | KJ/JLM | |
| G | 12.03.08 | Dimension R and Y revised | KJ | <i>M</i> |

| W/O: | | WORK ORDER CHANGES | | | | | |
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


Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

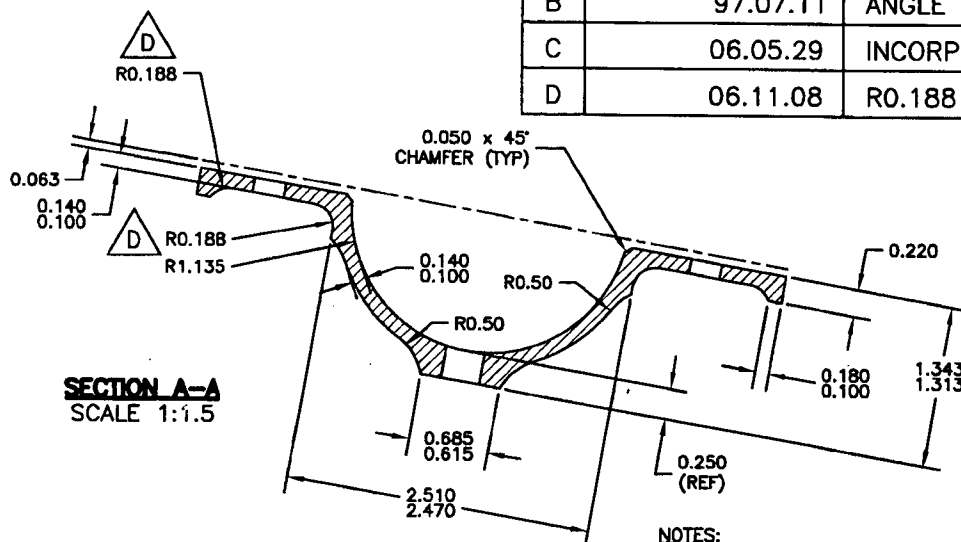
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

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|--|----------|---|--|--|------------------------|
| DESIGN  | | DRAWN BY  | | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED  | | APPROVED  | | DRAWING NO. D2665 | REV. D SHEET 1 OF 1 |
| DATE 06.11.08 | | | TITLE SADDLE FWD OUTSIDE HIGH SCALE 1:3 | | |
| A | 97.03.25 | | NEW ISSUE | | |
| B | 97.07.11 | | ANGLE AND NOTES ADDED | | |
| C | 06.05.29 | | INCORPORATE DEO 9122, 9102, 9095 | | |
| D | 06.11.08 | | R0.188 WAS R0.30; ø0.316 WAS ø0.313 | | |

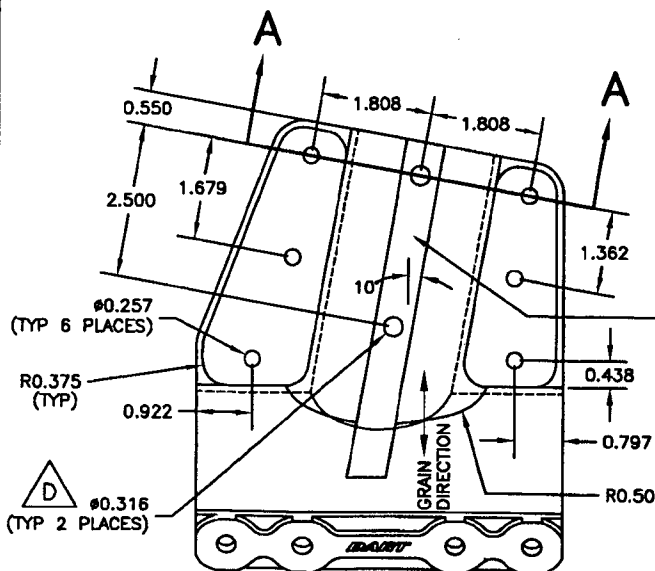


RELEASED

07.02.12

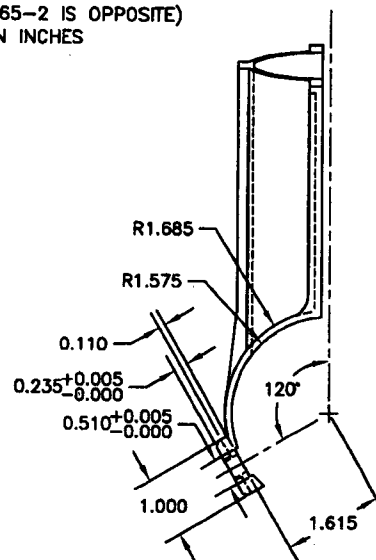
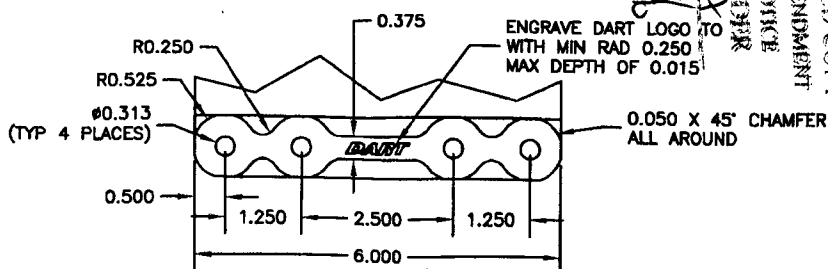
NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010

UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 810947
ML5 12/09

**D2665-1 SADDLE FWD OUTSIDE HIGH**

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Dart Aerospace Ltd

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